

Date: Thursday, 10/18/2007 8:04:20 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE
Job Number : 35226	
Estimate Number : 12924	
P.O. Number :	Part Number : D29321P
This Issue : 10/18/2007 S.O. No. :	Drawing Number : D2932 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 34601	Material :
Written By :	Due Date : 11/5/2007 Qty: 9 Um: Each
Checked & Approved By : <u>10/07.10.18</u>	
Comment : Est Rev:A New Issue 07-07-04 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	7075-T7351 2X6.25X7.875
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Comment: Qty: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

7075-T7351-2X6.25X7.875

Issue material from stock:

7075-T7351 Cut Size 2.0 x 6.25 X 7.880 Grain Along Long 7.88 Length

Batch No: 34873 DTP 08/03/11

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

5-Deburr & TUMBLE

DTP 08/03/15

SF 08/03/13

P10

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

SF 08/03/14

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

DTP 08/03/15

SF 08/03/14

P10

A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2932-1 PAR #: 11A Fault Category: Prod / Machined Parts NCR: Yes No DQA: ID Date: 08/09/27
4058-672 QA: N/C Closed: _____ Date: _____

NCR: <u>35226</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08.03.27</u>	<u>4</u>	<u>SADDLE #2</u> <u>DIMENSION 'D' IS 0.529"</u>	<u>RE</u> <u>08.03.27</u> <u>QSI</u> <u>042</u>	<u>PART WAS TRIED ON SKIDTUB</u> <u>CROSSTUBE.</u> <u>FIT WAS ACCEPTABLE</u> <u>SEE ATTACHED.</u>	<u>RE</u> <u>08.03.27</u> <u>QSI</u> <u>042</u>	<u>08/09/27</u>		<u>08/09/27</u>
<u>08.03.27</u>	<u>4</u>	<u>SADDLE #3</u> <u>DIMENSION 'D' IS 0.513"</u>	<u>RE</u> <u>08.03.27</u> <u>QSI</u> <u>042</u>	<u>PART DID NOT FIT</u> <u>CORRECTLY</u> <u>DIMENSION 0.600" WAS</u> <u>FOUND TO BE 0.563"</u>	<u>SCRAP</u> <u>PART</u>	<u>08/09/27</u>	<u>08.03.27</u>	<u>08/09/27</u>
				<u>SADDLE WAS GIVEN</u> <u>to Eng.</u>	<u>08/09/27</u>	<u>08/09/27</u>		<u>08/09/27</u>

NOTE: Date & initial all entries

Date: Thursday, 10/18/2007 8:04:20 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE

Job Number: 35226

Part Number: D29321UP

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SD 08/04/02

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M.A. 08/04/02

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

SL 08-04-03 (X9)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST428

AS 08/04/04 (X9)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/08

Job Completion



W.D. 08.04.04

66 powder coat white
per QSI 005
M 107550 08-04-03

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 35226
Description: 206 Saddle, Outboard, Left side	Part Number: D2932-1
Inspection Dwg: D2932 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.126	.117	.117	0.121		
B	0.100	0.140		.124	.118	.114	0.123		
C	0.100	0.140		.128	.118	.115	0.117		
D	0.210	0.230		.227	.227	.227	.227		
E	1.245	1.255		1.249	1.25	1.249	1.249		
F	1.245	1.255		1.249	1.249	1.249	1.249		
G	2.495	2.505		2.499	2.499	2.498	2.499		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.579	1.579	1.579	1.579		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.313	.3145	0.3145	0.3145		
M	0.235	0.240		.237	.237		.237		
N	0.100	0.140		.109	.122	.122	.122		
O	0.540	0.560	2.5 →	.540	0.529	0.522	0.540	2.5	
P	0.490	0.510		.504	0.502	0.502	0.501		
Q	3.715	3.725		3.718	3.718	3.718	3.718		
R	2.470	2.510		2.500	2.500	2.500	2.500		
S	0.240	0.270		.256	.242	.245	0.251		
T	0.100	0.180		.134	0.132	0.132	0.137		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.368	1.368	1.368	1.368		
W	0.316	0.321		.321	.321	.321	.321		
X	1.125	1.145		1.133	1.133	1.133	1.1366		
Y	1.565	1.585		1.573	1.574	1.575	1.575		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: S.F.
Date: 08/03/14

Audited by: SA
Date: 08/04/102

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART

Description

Inspection

Inspect dir

Dim	M
A	0.1
B	0.1
C	0.1
D	0.2
E	1.2
F	1.2
G	2.4
H	0.5
I	1.57
J	2.49
K	0.25
L	0.31
M	0.23
N	0.10
O	0.54
P	0.49
Q	3.715
R	2.470
S	0.240
T	0.100
U	1.625
V	1.362
W	0.316
X	1.125
Y	1.565
Z	0.178
AA	
AB	
AC	
AD	
AE	
AF	
AG	
AH	

Accept

Measured by
Date

Rev	Date
A	
B	02.12.12
C	07.03.21

DART AEROSPACE LTD

Work Order: 35226

Description: 206 Saddle, Outboard, Left side

Part Number: D2932-1

Inspection Dwg: D2932 Rev. C

Page 1 of 1

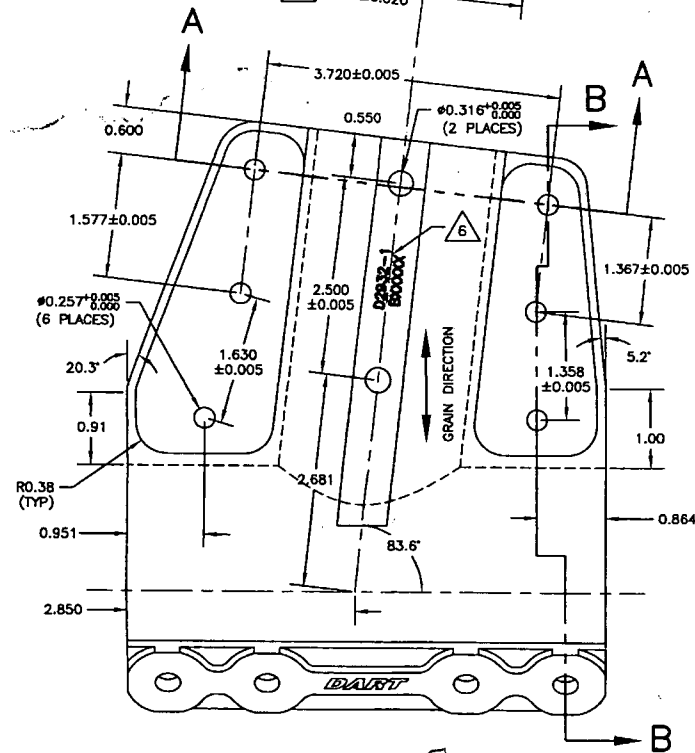
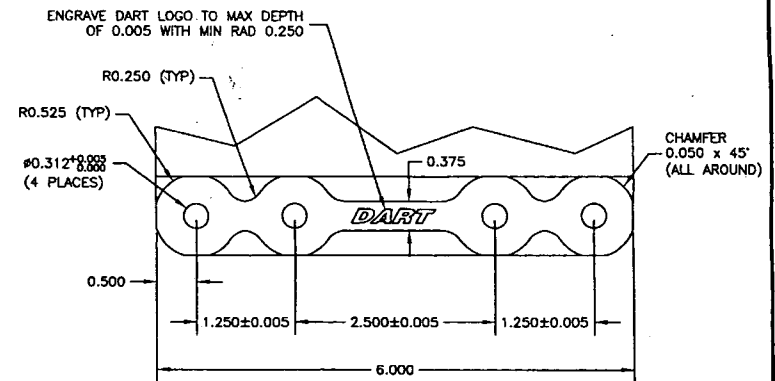
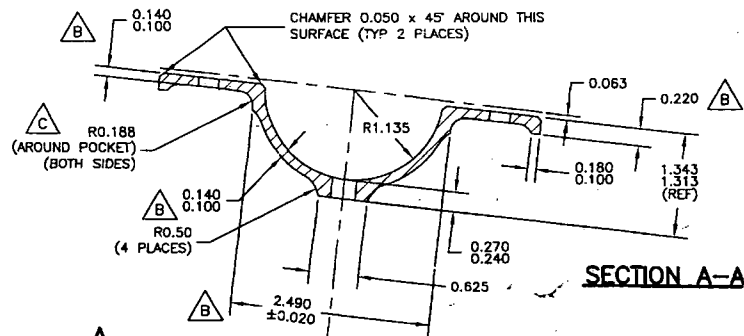
Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5	6	7	8		
A	0.100	0.140		0.122	0.122	0.122	0.127		
B	0.100	0.140		0.126	0.125	0.126	0.127		
C	0.100	0.140		0.109	0.118	0.110	0.120		
D	0.210	0.230		0.227	0.223	0.222	0.222		
E	1.245	1.255		1.2495	1.2495	1.250	1.250		
F	1.245	1.255		1.2495	1.2495	1.249	1.250		
G	2.495	2.505		2.500	2.501	2.5015	2.499		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.579	1.576	1.576	1.576		
J	2.495	2.505		2.500	2.499	2.500	2.500		
K	0.257	0.262		0.258	0.259	0.259	0.259		
L	0.312	0.317		0.314	0.315	0.315	0.315		
M	0.235	0.240		0.237	0.237	0.237	0.237		
N	0.100	0.140		0.122	0.123	0.122	0.122		
O	0.540	0.560		0.558	0.551	0.553	0.555		
P	0.490	0.510		0.500	0.494	0.494	0.491		
Q	3.715	3.725		3.720	3.716	3.717	3.718		
R	2.470	2.510		2.500	2.490	2.493	2.492		
S	0.240	0.270		0.252	0.254	0.254	0.253		
T	0.100	0.180		0.138	0.135	0.138	0.138		
U	1.625	1.635		1.635	1.629	1.630	1.627		
V	1.362	1.372		1.370	1.3675	1.368	1.368		
W	0.316	0.321		0.321	0.321	0.321	0.321		
X	1.125	1.145		1.1363	1.1366	1.1355	1.135		
Y	1.565	1.585		1.5755	1.576	1.5741	1.573		
Z	0.178	0.198		0.188	0.1880	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									

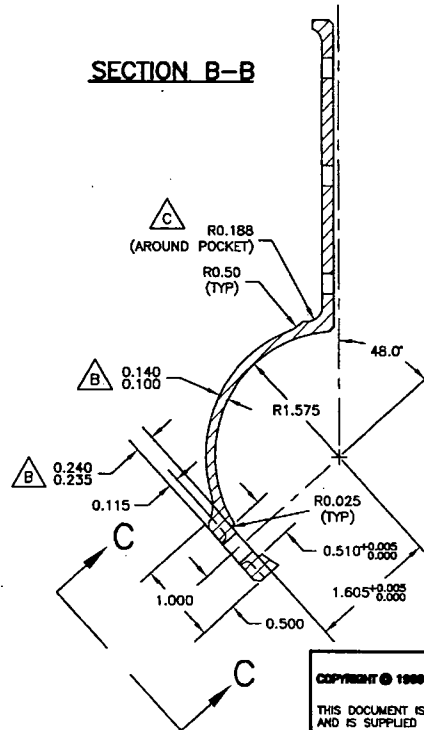
Accept/Reject

Measured by: JF
Date: 08/03/14DJP
08/03/15Audited by: SA
Date: 08/04/02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	



SECTION B-B



D2932-1 LH SADDLE (SHOWN) D2932-2 RH SADDLE (OPPOSITE)

- NOTES:
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	4	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	
DRAWING NO.	D2932	REV. C
TITLE	SADDLE OUTSIDE	SHEET 1 OF 1
		SCALE
		2:3

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